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D3914-041
Job Sheet 166569



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	11/9/17	0.00	0.00	Start up container	
100	Large Fab	1 pcs	11/9/17	0.00	6.67	Large Fab 1	
110	QC	1 pcs	11/9/17	0.00	0.00	QC9	
120	QC	1 pcs	11/9/17	0.00	0.00	QC5	
130	Powdercoat	1 pcs	11/9/17	0.00	0.40	Powdercoat4	
135	QC	1 pcs	11/9/17	0.00	0.00	QC3	
140	HandFinish	1 pcs	11/10/17	0.00	0.80	HandFinish3	
150	QC	1 pcs	11/10/17	0.00	0.00	QC3	
160	Packaging	1 pcs	11/10/17	0.00	0.00	Packaging3	
170	QC21-SA	1 Ea	11/10/17	0.00	0.00	QC21	

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***

130 - *** mask sides of hinge prior to powdercoat***

140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 16444/6	2	32	0	0
	D3914-1	2	6	0	0
	D3914-75000711	2	4	0	0
	D4016-3	3	25	0	0
	D4018-5 5002783	9	27	0	0
	D4020-5	1	2	0	0
	D4021-3 165512	1	9	0	0
	D4035-043	2	4	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____ Step #: _____ QTY Effective : _____ MRB (QS1042) Approval _____

Description Work Order Deviation _____ Disposition _____

DART
AEROSPACE
S008554



Long Basket Lid Assembly (350)

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Completed By _____

Lead hand / Supervisor
Approval Verification _____QC / QA Coordinator
Approval _____

Root Cause	
Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

PART NO:
Revision:
Operation:
Change No:

D3914-041**Start up Operation**

Mfg Date: 11/10/17
Job No: 166569

ge ☐	Positioned Wrong
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
ulled ☐	Part Lost/Missing
ce ☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

Heat Treat ☐Cut too short ☐Wave/Twist in Tube ☐Instructions Incomplete/Unclear ☐Fit/Function ☐Marks/Chatter ☐Drill Holes ☐Misaligned/off center ☐

OTHER: _____

